

**Work Order ID 73210**

Page 1

Friday, August 26, 2011 7:57:09 AM

Item ID: D206-642-541

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 9/6/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start

Approvals: Process Plan: CL Date: 11/08/26

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3274

D

IIN-D206-642

Rev M

100

0.00



DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy bluefile &amp; type labels per PPP D206-642-541

CHG003

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

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Stop

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Sequence ID/  
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Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110

0.00



Skidtubes

Skidtubes

0.00

**Memo**

\*\*\*\*VERIFY AND INSPECT THE MATERIAL PRIOR TO USE\*\*\*\*

1- Bend FWD end of tube using bend prog D3274 FWD and foil 10 as per dwg D3274, cut fwd end of tube with saw table setup D3274.

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

3- weld fwd cap as per dwg D3274 and OSI004

AR Aluminum Rod Batch: M12B60

4- grind fwd cap weld on top surface only

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D.  
Drill 3/16" pilot holes as per Dwg D3274

8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

DP 11-9-14

DL 11/09/15

BE 11/09/15

DL 11/09/19

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

114

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

116

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing



11-9-20

JW

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
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DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11-9-20

150

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 &amp; QSI 015.

A/R ☐ Sikaflex-291 ☒ 118393 ☐Sikaflex expire date: ☐ 12/04/05 ☐Start: ☒ 11/09/30 ☐ Time: ☐ 1:00 pm.Finish: ☐ ☐ Time: ☐

(Adhere for 12 hours)

11/09/20

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
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|      |      |                                  |                             |                                 |                |                           |                       |                          |

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

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Tool #

Plan  
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QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

11-9-22



QC

Memo

0.00

Quality Control

170

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

SAD 11-09-22

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2  
OPEN HOLES TO .297" . Deburr3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD  
END OF TUBE  
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)  
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

SAD 11-09-23

①

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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|      |      |                    |    |      |     |                                     |                          |

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

|     |   |      |  |  |  |  |  |  |  |
|-----|---|------|--|--|--|--|--|--|--|
| 180 | QC5- Inspect part completeness to step on W/O | 0.00 |  |  |  |  |  |  |  |
|-----|---|------|--|--|--|--|--|--|--|



|    |      |      |  |  |  |  |  |  |  |
|----|------|------|--|--|--|--|--|--|--|
| QC | Memo | 0.00 |  |  |  |  |  |  |  |
|----|------|------|--|--|--|--|--|--|--|

Quality Control

DP

11-9-28

|     |  |      |  |  |  |  |  |  |  |
|-----|--|------|--|--|--|--|--|--|--|
| 190 |  | 0.00 |  |  |  |  |  |  |  |
|-----|--|------|--|--|--|--|--|--|--|



|           |  |      |  |  |  |  |  |  |  |
|-----------|--|------|--|--|--|--|--|--|--|
| Skidtubes |  | 0.00 |  |  |  |  |  |  |  |
|-----------|--|------|--|--|--|--|--|--|--|

Skidtubes

Memo

1-Insert D2649 &amp; D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod

A/R ☐ Aluminum Rod ☒ 117884

3-Grind cross bolt welds flush as per Dwg D3274.

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

11-09-28

11/09/29

11-9-29  
11-10-3

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
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| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

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Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description  | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 200                            | QC5- Inspect part completeness to step on W/O                   | 0.00                 |         |        |              |               |               |                  |                |
|                                |   |                      |         |        |              |               |               |                  |                |
| QC                             | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |   |                      |         |        |              |               |               |                  |                |
| 210                            | QC10- Inspect visual per QSI004- ground welds                   | 0.00                 |         |        |              |               |               |                  |                |
|                                |   |                      |         |        |              |               |               |                  |                |
| QC                             | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |   |                      |         |        |              |               |               |                  |                |
| 220                            | Pressure Wash per QSI005 4.3                                    | 0.00                 |         |        |              |               |               |                  |                |
|                                |   |                      |         |        |              |               |               |                  |                |
| HandFinish                     | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Hand Finishing                 | Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch |                      |         |        |              |               |               |                  |                |

IX Ø m-f 11/10/04

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
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|      |      |                                  |                             |                                 |                |                           |                       |                          |
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|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

230

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

0.00

1X Ø m/11/10/04

240

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

i BL 11-10-4.

250

HandFinishing

0.00



HandFinish

Hand Finishing

Memo

0.00

1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets.

A/R□□Sikaflex-291 □ ~~117926~~ 114596.

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a

A/R□□Sikaflex-291 □ ~~118013~~ □□Sikaflex expire date: □ ~~2-5~~.

1 BL 11-10-4.

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
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| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



**Work Order ID 73210**

Friday, August 26, 2011 7:57:09 AM



Page 9

Item ID: D206-642-541

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 9/6/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

260

QC5- Inspect part completeness to step on W/O

0.00

S 11/10/11



QC

Memo

0.00

Quality Control

Inspect Nut Plate &amp; Inserts

(TU)

270

HAND FINISHING RESOURCE #1

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install wearpads &amp; gaskets as per Dwg D3274.

2-Install ring as per Dwg D3274

A/R ☐ Sikaflex-291 ☐ 11 8393 ☐Sikaflex expire date: ☐ 12-3 ☐

3-Inspect for foreign objects as per QSI 024

4-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3 Batch: N/A

5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R ☐ Sikaflex-291 ☐ 11 8393 ☐Sikaflex expire date: ☐ 12-3 ☐

PROCYON. M 114596

1 BL 11-10-4.

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 73210**

Friday, August 26, 2011 7:57:09 AM



Page 10

Item ID: D206-642-541

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 9/6/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



| Sequence ID/<br>Work Center ID    | Operation<br>Description                                  | Set Up/<br>Run Hours | Tool ID | Tool #    | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp            |
|-----------------------------------|---|----------------------|---------|-----------|--------------|---------------|---------------|------------------|---------------------------|
| 280<br><br>QC<br>Quality Control  | QC5- Inspect part completeness to step on W/O<br><br>Memo | 0.00<br><br>0.00     |         | 8 util/15 |              |               |               |                  |                           |
| 290<br><br>Packaging<br>Packaging | Identify as per dwg & Stock Location: _____<br><br>Memo   | 0.00<br><br>0.00     |         | PP 73117  |              |               |               |                  | 11/10/5 SP                |
| 300<br><br>QC<br>Quality Control  | QC21- Final Inspection - Work Order Release<br><br>Memo   | 0.00<br><br>0.00     |         |           |              |               |               |                  | 11/10/5 JH<br><br>11/10/5 |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Friday, August 26, 2011 7:57:06 AM

Page 1

Work Order ID: 73210

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube



Start Date: 9/6/2011

Required Date: 9/6/2011

Start Qty: 1.00

Required Qty: 1.00

**Comments:**

IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM  
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM  
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD  
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC  
 IPP Rev:F 08-06-02 add comment DD verified by:EC  
 IPP Rev:G 08-10-09 revise details DD verified by:EC

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D2600-1-190<br>                 |                        | Manufactured  | No          |                     |                  | 110             | Each               | 81.4000        | 1           | 1            |               |                |        |
| Extrusion Round 3" 206          |                        |               |             |                     |                  |                 |                    |                |             |              |               |                |        |
|                                 |                        |               |             | <u>Location</u>     | <u>Loc Qty</u>   | <u>Loc Code</u> |                    |                |             |              |               |                |        |
|                                 |                        |               |             | HALL                | 81.4             |                 |                    |                |             |              |               |                |        |
|                                 |                        |               |             | 59874               | 22.4             |                 |                    |                |             |              |               |                |        |
|                                 |                        |               |             | 69622               | 59               |                 |                    |                |             |              |               |                |        |
| D3285-1<br>                     |                        | Manufactured  | No          |                     |                  | 110             | Each               | 92.0000        | 1           | 1            |               |                |        |
| Cap                             |                        |               |             |                     |                  |                 |                    |                |             |              |               |                |        |
|                                 |                        |               |             | <u>Location</u>     | <u>Loc Qty</u>   | <u>Loc Code</u> |                    |                |             |              |               |                |        |
|                                 |                        |               |             | LG002               | 92               |                 |                    |                |             |              |               |                |        |
|                                 |                        |               |             | 52511               | 45               |                 |                    |                |             |              |               |                |        |
|                                 |                        |               |             | 52647               | 47               |                 |                    |                |             |              |               |                |        |
| D3282-041<br>                   |                        | Manufactured  | No          |                     |                  | 150             | Each               | 2.0000         | 1           | 1            |               |                |        |
| Float Web (206L/407)            |                        |               |             |                     |                  |                 |                    |                |             |              |               |                |        |
|                                 |                        |               |             | <u>Location</u>     | <u>Loc Qty</u>   | <u>Loc Code</u> |                    |                |             |              |               |                |        |
|                                 |                        |               |             | LG                  | 2                |                 |                    |                |             |              |               |                |        |
|                                 |                        |               |             | 72838               | 2                |                 |                    |                |             |              |               |                |        |
|                                 |                        |               |             | 69714               | 2                |                 |                    |                |             |              |               |                |        |

11-9-14

BE 11/09/15

Whe

11/09/20

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Friday, August 26, 2011 7:57:06 AM

Work Order ID: 73210

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 9/6/2011

Required Date: 9/6/2011

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

190 Each

46.0000 12 12



Cross Bolt Spacer



*11.09.28*

Location

Loc Qty

Loc Code

LG 373851 34  
 68224 2  
 71355 2  
 72704 30  
 LG001 12  
 65317 1  
 68507 11

12

D3275-1

Manufactured No

190 Each

280.0000 12 12



Crossbolt Spacer



*11.10.06*

Location

Loc Qty

Loc Code

LG 373393 161  
 72123 161  
 LG002 119  
 66930 106  
 68946 13

6  
6

CR3212-4-03

Purchased No

250 Each

1,158.000 2 2



Cherry Rivet



*11-10-4*

Location

Loc Qty

Loc Code

FP-B 2  
 110139 2  
 ST311 1156  
 114859 ✓ 1156

2

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



# Picklist Print

Friday, August 26, 2011 7:57:06 AM

Work Order ID: 73210



Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 9/6/2011

Required Date: 9/6/2011

Start Qty: 1.00

Required Qty: 1.00

D3415-041 Manufactured No

250 Each

50.0000

1

1



Nut Plate



BL 11-10-11

Location

Loc Qty

Loc Code

ST053

50

33842

6

67605 ✓

44

CCR264SS3-3

Purchased No

250 Each

459.0000

2

2



Cherry Rivet



BL 11-10-11

Location

Loc Qty

Loc Code

FP-B

2

113973

2

ST311

457

117086

31

117849 ✓

426

ALS4-1032-130

Purchased No

250 Each

1,416.000

78

78



Insert



BL 11-10-11

Location

Loc Qty

Loc Code

ST281

370

118386

370

ST282

1046

117717 ✓

54

118237

736

118312

256

ALS7-1032-130 ✓

78

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Friday, August 26, 2011 7:57:06 AM

Work Order ID: 73210

Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 9/6/2011



Required Date: 9/6/2011

Start Qty: 1.00



Required Qty: 1.00

|   |              |    |     |      |         |   |   |                    |
|---|--------------|----|-----|------|---------|---|---|--------------------|
| D3536-15  | Manufactured | No | 270 | Each | 22.0000 | 1   | 1 |                    |
|  |              |    |     |      |         |  |   | <u>BR 11-10-4.</u> |
| Gasket  |              |    |     |      |         |   |   |                    |



| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FP011           | 22             |                 |
| 71586 ✓         | 13             | <u>1</u>        |
| 72881           | 9              |                 |

|   |              |    |     |      |         |   |   |                    |
|---|--------------|----|-----|------|---------|---|---|--------------------|
| D3536-23  | Manufactured | No | 270 | Each | 18.0000 | 1   | 1 |                    |
|  |              |    |     |      |         |  |   | <u>BR 11-10-4.</u> |
| Gasket  |              |    |     |      |         |   |   |                    |

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FP011           | 18             |                 |
| 43406           | 1              |                 |
| 69902           | 5              | <u>1</u>        |
| 71579 ✓         | 12             |                 |

|   |              |    |     |      |         |   |   |                    |
|---|--------------|----|-----|------|---------|---|---|--------------------|
| D3536-35  | Manufactured | No | 270 | Each | 23.0000 | 1   | 1 |                    |
|  |              |    |     |      |         |  |   | <u>BR 11-10-4.</u> |
| Gasket  |              |    |     |      |         |   |   |                    |

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FP012           | 23             |                 |
| 71587 ✓         | 13             | <u>1</u>        |
| 72882           | 10             |                 |

|   |              |    |     |      |         |   |   |                    |
|---|--------------|----|-----|------|---------|---|---|--------------------|
| D3536-39  | Manufactured | No | 270 | Each | 20.0000 | 1   | 1 |                    |
|  |              |    |     |      |         |  |   | <u>BR 11-10-4.</u> |
| Gasket  |              |    |     |      |         |   |   |                    |

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FP015           | 20             |                 |
| 69760 ✓         | 20             | <u>1</u>        |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Friday, August 26, 2011 7:57:06 AM

Work Order ID: 73210

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 9/6/2011

Required Date: 9/6/2011

Start Qty: 1.00

Required Qty: 1.00

D3535-15 Manufactured No

270 Each

9.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FP018

73006

9

69931

9

D3535-35 Manufactured No

270 Each

12.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FP018

73311

12

65926

1

67598

1

70815

10

D3535-39 Manufactured No

270 Each

19.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FP018

19

69759

6

72159

13

D3535-23 Manufactured No

270 Each

18.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FP021

18

70818

8

71581

10

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Friday, August 26, 2011 7:57:06 AM

Work Order ID: 73210

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 9/6/2011

Required Date: 9/6/2011

Start Qty: 1.00

Required Qty: 1.00

D3537-3 Manufactured No

270 Each

11.0000

1

1



Wearpad



BR 11-10-11

Location

Loc Qty

Loc Code

FP

5

70481

5

FP017

6

35697

1

72686

5

270 Each

66.0000

9

9

D3537-1 Manufactured No



Wearpad



BR 11-10-11

Location

Loc Qty

Loc Code

FP001

9

69530

9

FP016

50

68944

0

70687

50

FP017

7

69817

5

70686

2

270 Each

0.0000

80

80

AN960C10L NAS1149C0332 Purchased No



washer



80.

BR 11-10-11

AN960C416 NAS1149C0463 Purchased No



washer



1

BR 11-10-11

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



# Picklist Print

Friday, August 26, 2011 7:57:06 AM

Work Order ID: 73210



Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 9/6/2011

Required Date: 9/6/2011

Start Qty: 1.00

Required Qty: 1.00

D3672-1 Manufactured No

270 Each

1,180.000 2 2



Phenolic Washer



BR 11-10-11

Location

Loc Qty

Loc Code

ST074

1178

64177

182

66821 ✓

496

72229

500

2

ST077

2

52505

2

AN3C4A

Purchased No

270 Each

2,109.000 80 80



BR 11-10-11

BOLT

Location

Loc Qty

Loc Code

ST350

2109

117313

2

117688

36

117795

1

117872

22

118012

20

118112

40

118451 ✓

1000

118628

988

80

AN4C5A

Purchased No

270 Each

487.0000 1 1



BR 11-10-11

BOLT

Location

Loc Qty

Loc Code

FP-B

98

112243 ✓

98

1

ST345

389

112243

389

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Page 8

Friday, August 26, 2011 7:57:06 AM

Work Order ID: 73210



Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 9/6/2011

Required Date: 9/6/2011

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

270

Each

93.0000

1

1



Aft Cap



BR 11-10-4.

Location

Loc Qty

Loc Code

FP004

46

68280

46

FP006

5

62678

5

FP-4

38

70945

1

71070 ✓

37

fp5

4

71038

4

D3413-1

Manufactured No

270

Each

23.0000

1

1



Ring



BR 11-10-4.

Location

Loc Qty

Loc Code

ST420

23

72137.

66387

1

70773

22

1

Friday, August 26, 2011 7:57:07 AM

Shop Packet Print

Page 8

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**DART**

RELEASED

07.02.12

DEO ATTACHED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 73210  
C21103/24

|                  |                |  |                        |
|------------------|----------------|--|------------------------|
| DESIGN<br>CP     | DRAWN BY<br>PH | DART AEROSPACE USA, INC.<br>PORT HADLOCK, WA |                        |
| CHECKED<br>H     | APPROVED<br>H  | DRAWING NO.<br>D3274                         | REV. D<br>SHEET 1 OF 4 |
| DATE<br>06.12.19 |                | TITLE<br>SKIDTUBE ASSEMBLY                   | SCALE<br>NTS           |
| A                | 04.03.15       | NEW ISSUE                                    |                        |
| B                | 04.08.09       | MOVE SADDLE HOLE: 42.14 WAS 42.76            |                        |
| C                | 05.03.16       | ADD -043; NEW INSERTS                        |                        |
| D                | 06.12.19       | NEW INSERTS, SS WEARSHOE + GASKET            |                        |

| Qty<br>-041 | Qty<br>-043 | Part Number   | Description   |
|-------------|-------------|---------------|---|
| X           |             | D3274-041     | SKIDTUBE ASSEMBLY                                       |
|             | X           | D3274-043     | SKIDTUBE ASSEMBLY                                       |
| 1           | 1           | D2600-1-240   | EXTRUSION   |
| 1           | 1           | D2646         | AFT CAP   |
| 12          | 12          | D2649         | CROSS BOLT SPACER                                       |
| 12          | 37          | D3275-1       | CROSS BOLT SPACER                                       |
| 1           | 1           | D3282-041     | FLOAT WEB   |
| 1           | 1           | D3285-1       | CAP   |
| 1           | 1           | D3413-1       | RING  |
| 1           | 1           | D3415-041     | NUT PLATE   |
| 1           | 1           | D3535-15      | WEARSHOE  |
| 1           | 1           | D3535-23      | WEARSHOE  |
| 1           | 1           | D3535-35      | WEARSHOE  |
| 1           | 1           | D3535-39      | WEARSHOE  |
| 1           | 1           | D3536-15      | GASKET  |
| 1           | 1           | D3536-23      | GASKET  |
| 1           | 1           | D3536-35      | GASKET  |
| 1           | 1           | D3536-39      | GASKET  |
| 9           | 9           | D3537-1       | WEARPAD   |
| 1           | 1           | D3537-3       | WEARPAD   |
| 78          | 78          | ALS7-1032-130 | INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130) |
| 80          | 80          | AN3C4A        | BOLT  |
| 1           | 1           | AN4C5A        | BOLT  |
| 1           | 1           | AN960C416     | WASHER  |
| 80          | 80          | AN960C10L     | WASHER  |
| 2           | 2           | CCR264SS3-3   | RIVET   |
| 2           | 2           | CR3212-4-03   | RIVET   |
| 2           | 2           | NAS1515H3L    | WASHER  |

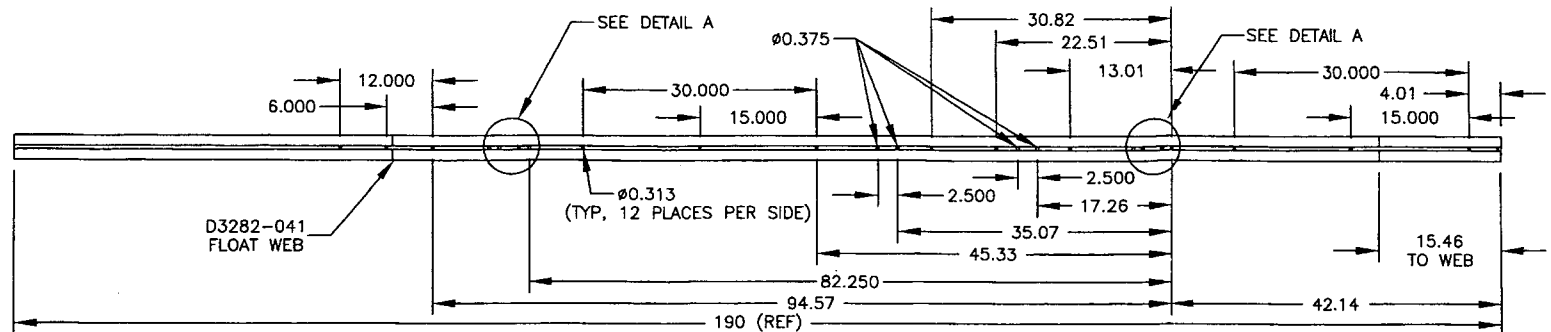
**GENERAL NOTES:**

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1  
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

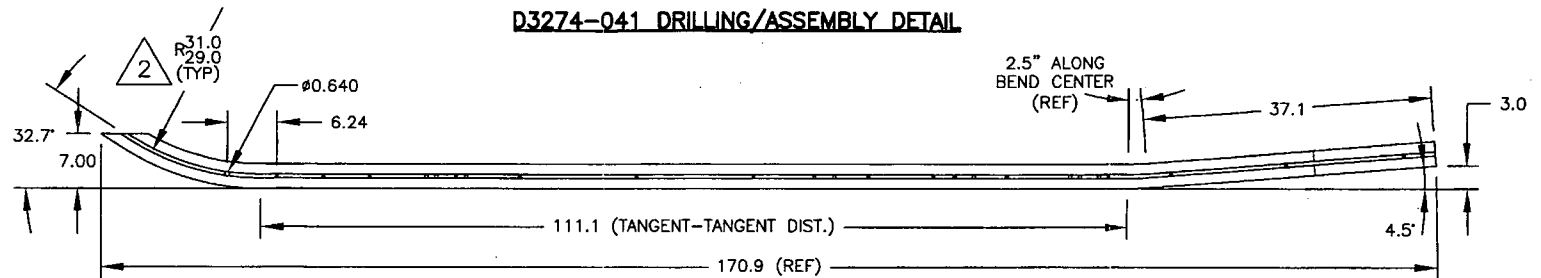
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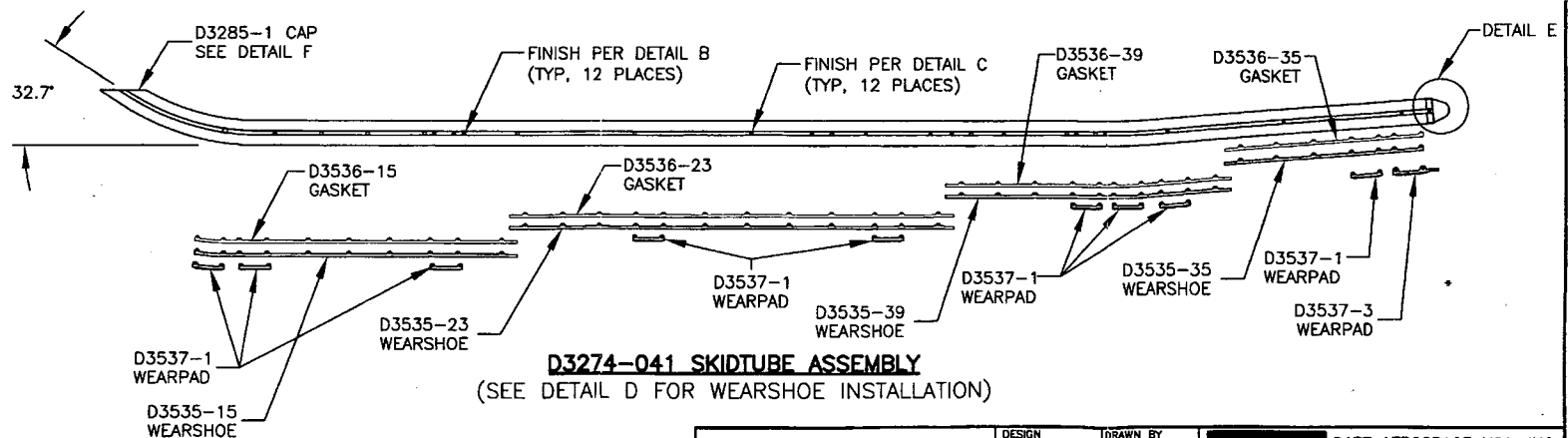
DEO ATTACHED



**D3274-041 DRILLING/ASSEMBLY DETAIL**



**D3274-041 BEND/DRILLING DETAIL**



**D3274-041 SKIDTUBE ASSEMBLY**  
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

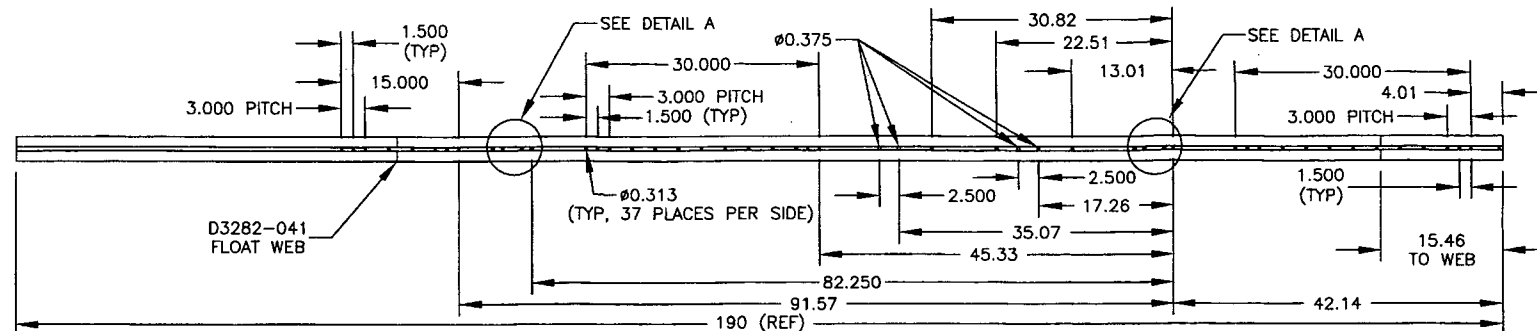
07.02.12

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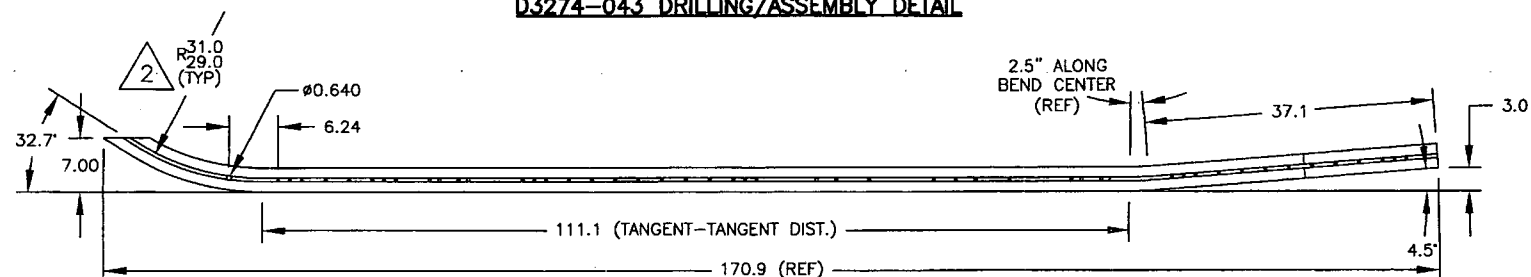
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| DESIGN  | CP       | DRAWN BY | PH                | <b>DART</b> | DART AEROSPACE USA, INC. |
| CHECKED | +        | APPROVED | +                 | DRAWING NO. | D3274                    |
| DATE    | 06.12.19 | TITLE    | SKIDTUBE ASSEMBLY | REV. D      | SHEET 2 OF 4             |
|         |          |          |                   | SCALE       | 1:15                     |

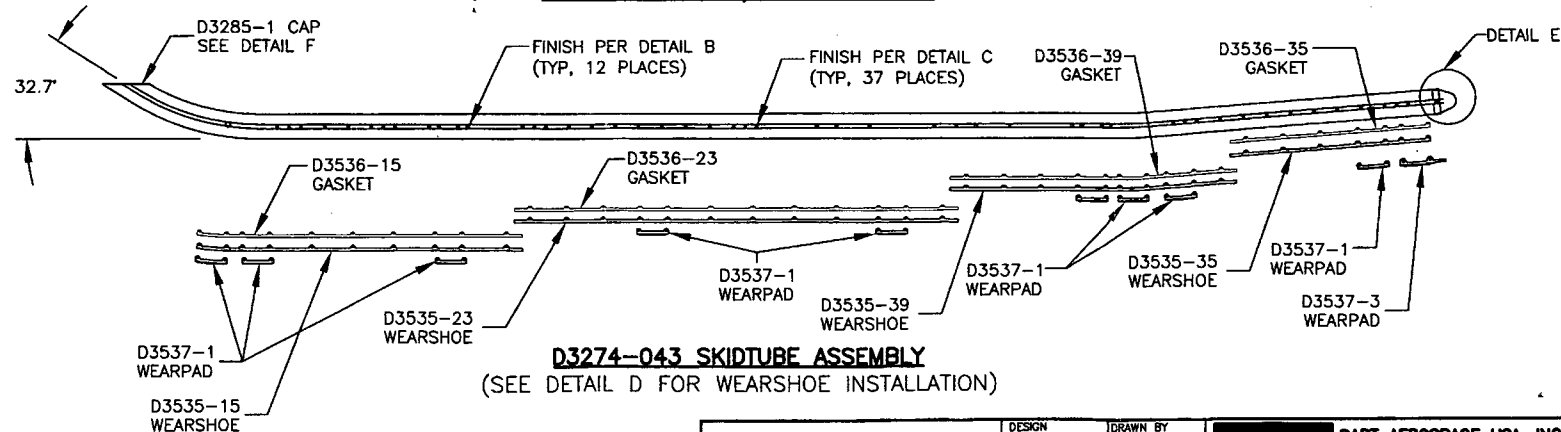
DEO ATTACHED



**D3274-043 DRILLING/ASSEMBLY DETAIL**



**D3274-043 BEND/DRILLING DETAIL**



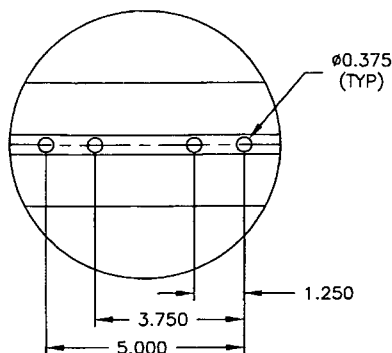
**D3274-043 SKIDTUBE ASSEMBLY**  
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

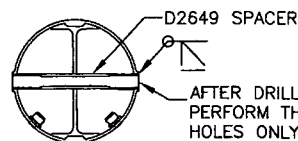
07.02.12

|   |  |          |             |                          |              |
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| CHECKED   |  | APPROVED | DRAWING NO. | D3274                    | SHEET 3 OF 4 |
| DATE  |  | 06.12.19 | TITLE       | SKIDTUBE ASSEMBLY        | SCALE        |
|   |  |          |             |                          | 1:15         |

# **DETAIL A: DRILL DETAIL**

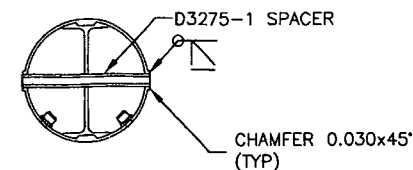


# **DETAIL B** FOR 0.375 HOLES ONLY

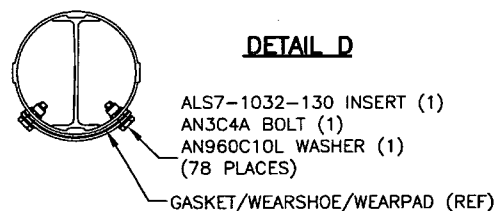


- AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR 0.375  
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
  2. INSERT D2649 SPACER
  3. WELD INTO PLACE AND GRIND FLUSH
  4. C'BORE TO 0.313x0.75 DEEP

# **DETAIL C** FOR 0.313 HOLES ONLY

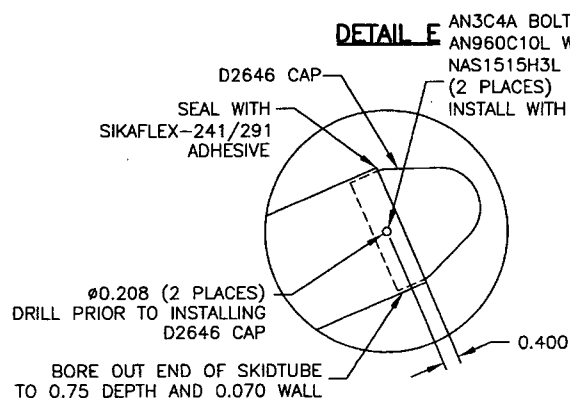


# **DETAIL D**



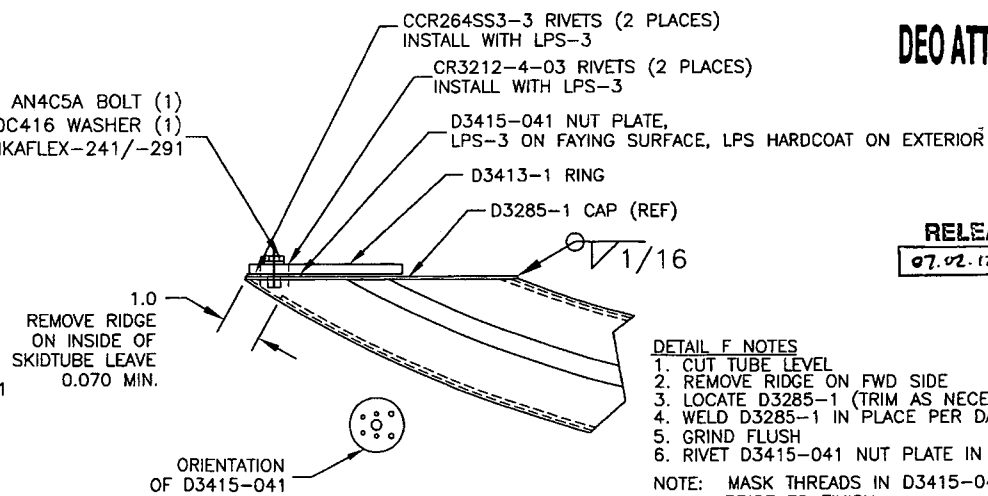
- ALS7-1032-130 INSERT (1)  
AN3C4A BOLT (1)  
AN960C10L WASHER (1)  
(78 PLACES)  
GASKET/WEARSHOE/WEARPAD (REF)

# **DETAIL E**



- AN3C4A BOLT (1)  
AN960C10L WASHER (1)  
NAS1515H3L WASHER (1)  
(2 PLACES)  
INSTALL WITH SIKAFLEX-241/-291

# **DETAIL F: END FINISHING DETAIL**



- 1.0  
REMOVE RIDGE  
ON INSIDE OF  
SKIDTUBE LEAVE  
0.070 MIN.

ORIENTATION  
OF D3415-041

- DETAIL F NOTES**
1. CUT TUBE LEVEL
  2. REMOVE RIDGE ON FWD SIDE
  3. LOCATE D3285-1 (TRIM AS NECESSARY)
  4. WELD D3285-1 IN PLACE PER DART QSI 004
  5. GRIND FLUSH
  6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041  
PRIOR TO FINISH

**DEO ATTACHED**

**RELEASED**

07.02.12

|  |  |         |          |          |                   |  |                        |
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|  |  | DATE    | 06.12.19 | TITLE    | SKIDTUBE ASSEMBLY | SCALE  | 1:3                    |



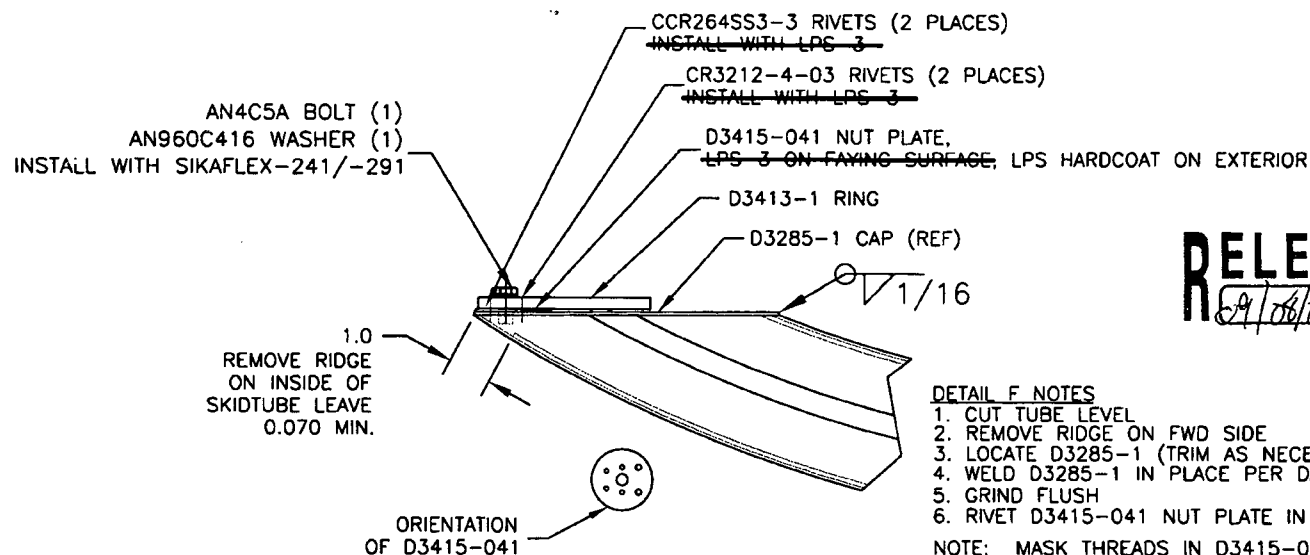
|                      |                            |                        |  |                         |                           |              |
|----------------------|----------------------------|------------------------|--|-------------------------|---------------------------|--------------|
| DRAWING NO.<br>D3274 | TITLE<br>SKIDTUBE ASSEMBLY | REV. D                 | <b>DART AEROSPACE USA, INC</b><br><b>ENGINEERING ORDER</b> | D.E.O. NO.<br>D3274-D-1 | SHEET NO.<br>SHEET 1 OF 1 | SCALE<br>NTS |
| DRAWN<br><i>UP</i>   | CHECKED<br><i>1</i>        | MFG. APPR.<br><i>1</i> | APPROVED<br><i>JAP</i>                                     | DE APPR.<br><i>1</i>    |                           |              |
| DATE<br>09.06.17     | DATE<br>09.06.23           | DATE<br>09/06/23       | DATE<br>09/06/23   | DATE<br>09.06.23        |                           |              |

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: "~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS 3' AFTER FINISH AND INSTALLATION OF INSERTS.~~  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

### DETAIL F: END FINISHING DETAIL



#### DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041  
PRIOR TO FINISH



NO. 267

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Pat Ewers  
Job number: 73212  
Part number: A206-642-541  
Description: Skid tube  
Welding Process: Tig[☒] Mig[☒] M  
Base material: Aluminum  
Current: AC[☒] DC[☐]

TEST REQUIREMENTS AND RESULTS

Visual:  
Penetration:

pass[☒] fail[☐]  
pass[☒] fail[☐]

UNACCEPTABLE

Cracks:  
Undercut:  
Pin holes:  
Overlap (cold lap)  
Porosity (surface):  
Coloration:

pass[☒] fail[☐]  
pass[☒] fail[☐]  
pass[☒] fail[☐]  
pass[☒] fail[☐]  
pass[☒] fail[☐]  
pass[☒] fail[☐]

Qualifier David Aural Date of Test Coupon 11.09.26  
Welder Pat Ewers Date of Test Coupon 11.09.26

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries